

Work Order ID 64454

Monday, December 06, 2010 10:21:44 AM



Page 1

Item ID: D2805-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Stop

Start Date: 12/6/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-12-06*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2805

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

ack 10/12/10

10

✓

Jcaspa Bandsaw

Cut Bar: 3.150" Long +0.010/-0.030"

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

ack 10/12/13

10

✓

HAAS CNC vertical machine #1

1- Machine as per Folio FA104 and Dwg D2805□2- Tumble and
Deburr□Identify as D2805-2

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

ack 10/12/13

10

✓

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64454

Monday, December 06, 2010 10:21:44 AM

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Item ID: D2805-2

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Setup Start

Revision ID:

Stop

Item Name: Stop

Start Date: 12/6/2010 Start Qty: 10.00

Required Date: 12/13/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 10/12/13



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

=> HQ 10/12/13



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 10/12-13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64454

Monday, December 06, 2010 10:21:44 AM

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Item ID: D2805-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Stop

Start Date: 12/6/2010 Start Qty: 10.00

Required Date: 12/13/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Signature: *[Handwritten Signature]*
Date: 10/12/15
Stamp: (10)

10/12/15 *[Handwritten Signature]*

mf

10-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:21:48 AM

Page 1

Work Order ID: 64454

Parent Item: D2805-2

Parent Item Name: Stop



Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B□00.11.14□Revised Finishing step to Acid etch and Alodine□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.50 0		Purchased	No			100	f	7.0252	0.2625	2.763158			



6061-T6 Bar 1.50 x 1.50



Location

Loc Qty

Loc Code

MAT10

7.0252

107244

1

→ 107432

6.0252

2.764 *OK 10/12/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

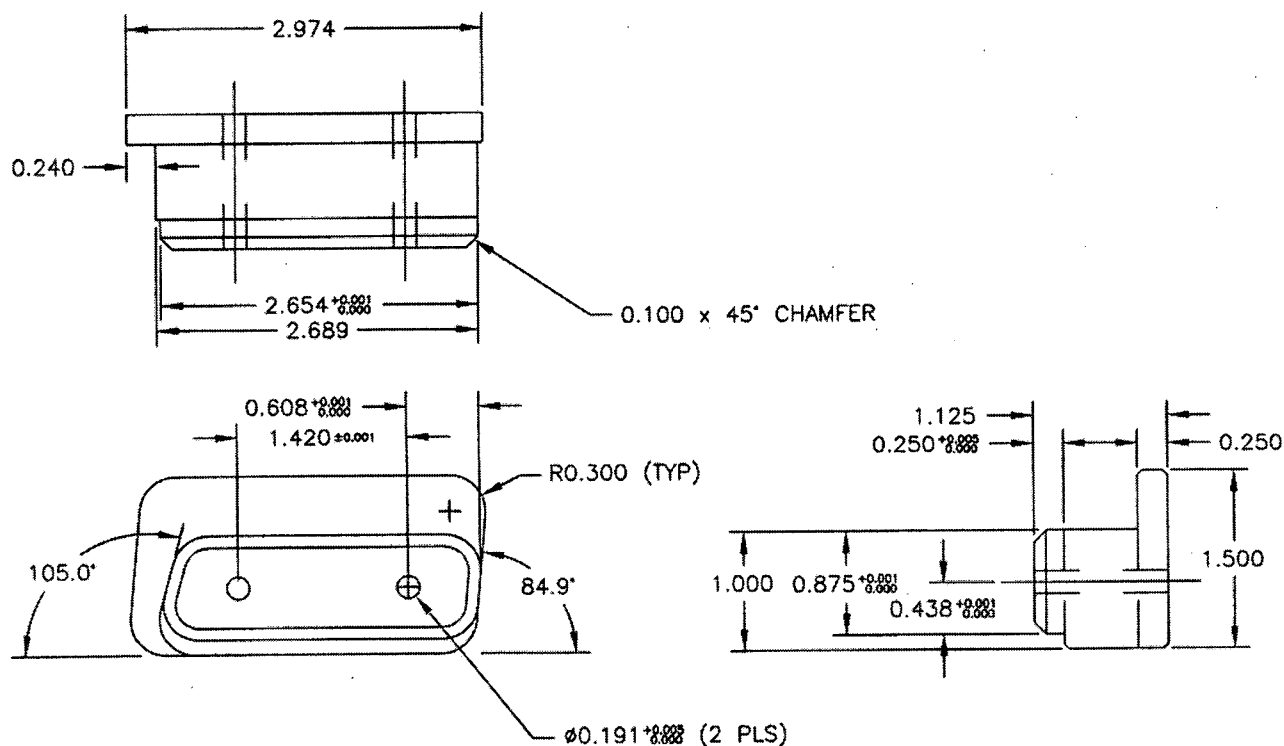
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
01.03.16 #



D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

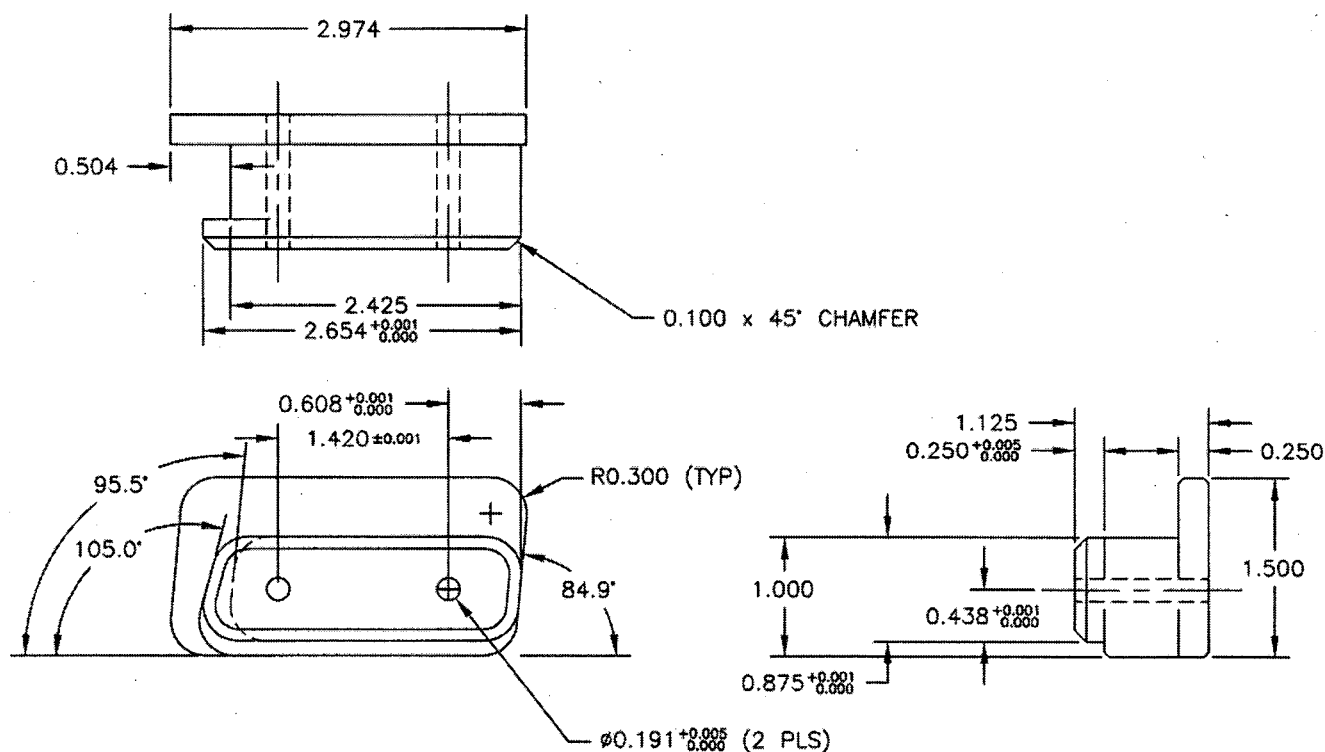
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DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

#64454

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